

Work Order ID 66194

February 7, 2011 12:38:52 PM



Page 1

Item ID: D3254-041

Accept



Setup Start



Revision ID:

Item Name: Side (LH)

Stop



Start Date: 2/07/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/02/07 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3254	Rev A

100 \_\_\_\_\_ 0.00

PURCHASING

Waterjet

Memo

0.00

B11-3-9

FLOW CNC Waterjet

2004.063

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

(4)

110 \_\_\_\_\_ 0.00

QC

Memo

0.00

B11-3-9

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66194**

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Chemical Conversion Coat per QSI005 4.1

0.00

4 4 2011-03-14

HandFinish

Memo

0.00

Hand Finishing

151



QC3- Inspect Part Finish

0.00

4 BR 11-3-14

QC

Quality Control

Memo

0.00

153



Small Fab

Memo

0.00

Small Fab

Install D3248-1 as per dwg

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 66194**

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Item ID: D3254-041

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Setup

Start



Revision ID:

Item Name: Side (LH)

Stop



Start Date: 2/07/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

157

QC5- Inspect part completeness to step on W/O

0.00

Sullosky



QC

Memo

0.00

Quality Control

170

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:00

OVEN TEMPERATURE:

330

FINISH TIME:

11:30

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

February 7, 2011 12:38:51 PM

Work Order ID: 66194



Parent Item: D3254-041



Parent Item Name: Side (LH)

Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3254-1 no longer made in-house  
11.02.07 made on W.J. DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	31.9270	3.3609	13.4436			

2024-T3 .063 sheet

B11-3-9

Location	Loc Qty	Loc Code	
MAT22	31.927		
114351	31.927		

117018 (4)

B11-3-9

8

B11-3-9

72

B11-3-9

11683 (72)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46078-06194
Description: Side (Dual Battery Rack)		Part Number:	D3254-1
Inspection Dwg: D3254 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/-0.030	5.203	✓		U RBO2	
4.15	+/-0.030	4.148	✗		U	
R0.19	+/-0.030	.19	✗		R.G.	
1.103	+/-0.010	1.103	✗		U	
0.300	+/-0.010	.300	✗		U	
Ø0.098	+0.005/-0.000	-101	✗		U	
1.300 Pitch	+/-0.005	1.301	✗		U	
21.056	+/-0.010	21.056	✗		T RBO1	
19.000	+/-0.010	19.00	✗		U	
1.003	+/-0.010	1.007	✗		U	
Ø1.125	+0.005/-0.000	1.125	✗		U	
5.403	+/-0.010	5.401	✗		U	
Ø0.257	+0.005/-0.000	-261	✗		U	
Ø1.500	+0.005/-0.000	1.503	✗		U	
2.750 Pitch	+/-0.005	2.747	✗		U	
5.500	+/-0.010	5.496	✗		U	
1.653	+/-0.010	1.658	✗		U	
3.75	+/-0.030	3.753	✗		U	
10.810	+/-0.010	10.805	✗		PRO WSO2	
8.00	+/-0.030	8.007	✗		U	
R0.50	+/-0.030	.50	✗		R.G.	
2.750 Pitch	+/-0.005	2.748	✗		U	
4.125	+/-0.010	4.125	✗		U	
1.375	+/-0.010	1.374	✗		U	
Ø0.128	+0.005/-0.000	.134	✗		U	
11.000	+/-0.010	10.998	✗		PRO	
22.946	+/-0.010	22.946	✗		T	
R0.30	+/-0.030	.30	✗		R.G.	
9.90	+/-0.030	9.901	✗		PRO	
11.77	+/-0.030	11.773	✗		PRO	
1.82	+/-0.030	1.820	✗		U	
2.17	+/-0.030	2.171	✗		U	
20.10	+/-0.030	20.10	✗		T	
0.953	+/-0.010	.950	✗		U	
R0.125	+/-0.010	.125	✗		R.G.	
Grain along 20.10	N/A		✗			

Measured by:	B
Date:	11-3-09

Audited by:	S
Date:	11/03/09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	JL

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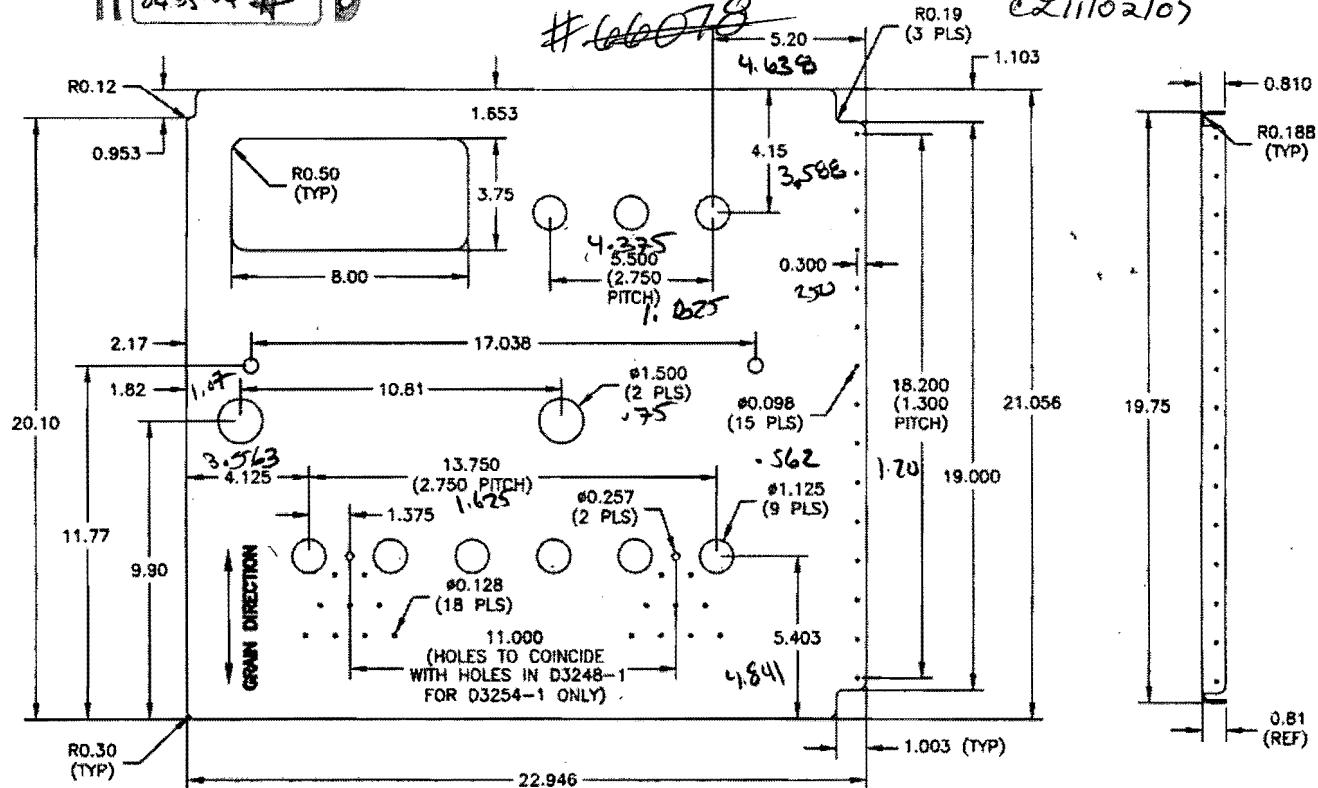


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3254 REV. A
DATE		SHEET 1 OF 1
04.04.06		TITLE SIDE (DUAL BATTERY RACK) SCALE 1:6

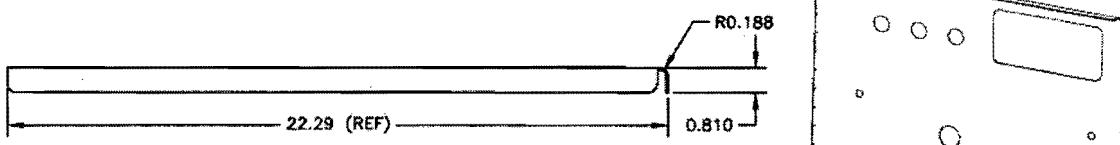
RELEASED  
04.05.04

A 04.04.06 NEW ISSUE

W10166184  
CL1110210

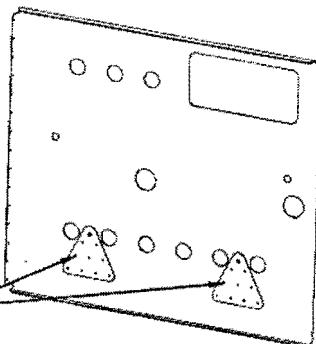


D3254-1/-2 FLAT PATTERN



D3254-1 BEND DETAIL (SHOWN)  
D3254-2 OPPOSITE

INSTALL D3248-1  
USING MS20470A4-5  
RIVETS



D3254-041

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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